

Work Order ID 133914

133914

June-24-15 12:53:03 PM

Page 1

Item ID: D3910-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug
 Start Date: 6/21/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 6/23/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3910	E

110 Outsource process - Machining 0.00

110

Outsource5

Outsource process - Machining

HAAS CNC VERTICAL MACHINING #1

Memo

Issue P/O to Metec : 28931
 Machine as per dwg
 C of C is required

0.00

CZ JUN 24 2015 30

120 Receive & Inspect for Damage & Mat'l Certs 0.00

120

Packaging

Packaging

Memo

Ensure C of C is attach

0.00

30x SP15-07-22

130 QC6- Inspect dimensions to drawing 0.00

130

QC

Quality Control

Memo

0.00

(30)

DAS
38
9-89

AUG 5 2015

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i>	<i>DAS</i> 38 9-89 0.00 0.00							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>N/A</i>	<i>DAS</i> 38 9-89 0.00 0.00							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo <i>N/A</i> START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	<i>DAS</i> 38 9-89 0.00 0.00							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							DAB 38
Quality Control									AUG 05 2015
180	Identify as per dwg & Stock Location <i>st 504</i>	0.00							
180									
Packaging	Memo	0.00							DAB 27
Packaging									9-29 AUG 06 2015
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									15/8/6 <i>JD</i>

SD 20150806

Picklist Print

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Page 1

Work Order ID: 133914

133914

Parent Item: D3910-7

D3910-7

Parent Item Name: Crosstube Lug

Start Date: 6/21/15

Required Date: 6/23/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 14.05.21 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423

Manufactured

No

f

511.2880

4

D2423

Lug Extrusion

CL JUN 24 2015

Location

Loc Qty

Loc Code

HALL

312

131451

312

Metec

199.288004

127892

199.288004

D3910-7P

Purchased

No

Each

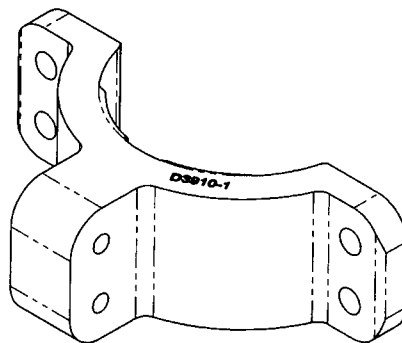
0.0000

30

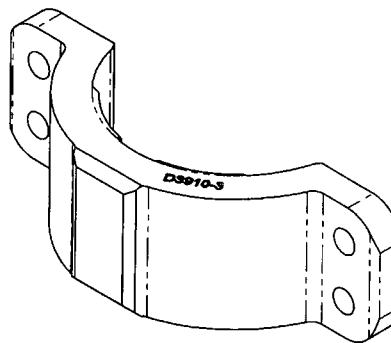
D3910-7P

Crosstube Lug

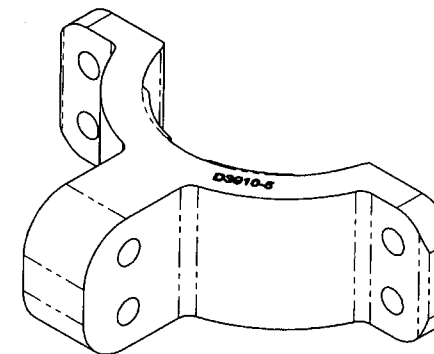
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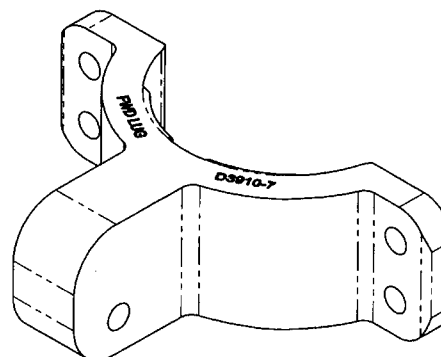
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005

SHOP COPY

WORKING
NO. 133914 MLG
15-06-24

RELEASED

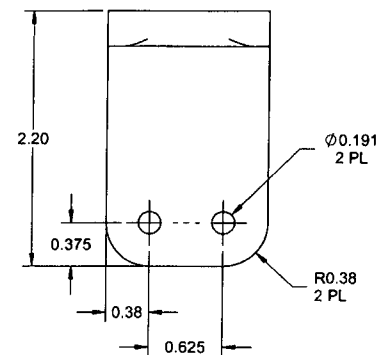
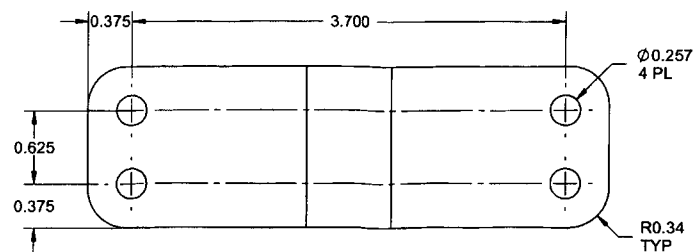
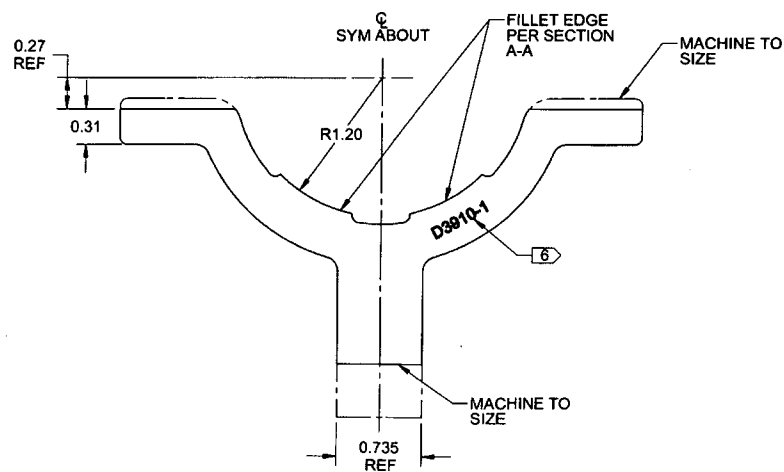
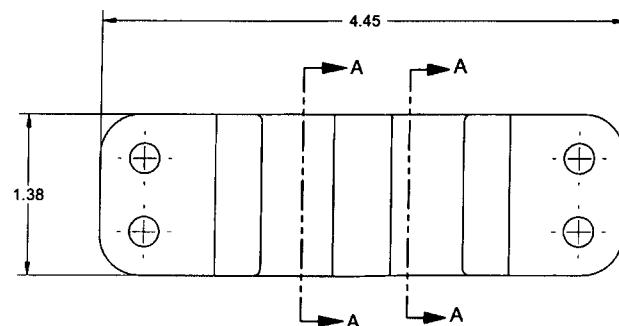
2014 JUN 05
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JPH	DRAWING NO.	REV. E
MFG. APPR.	JPH	D3910	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



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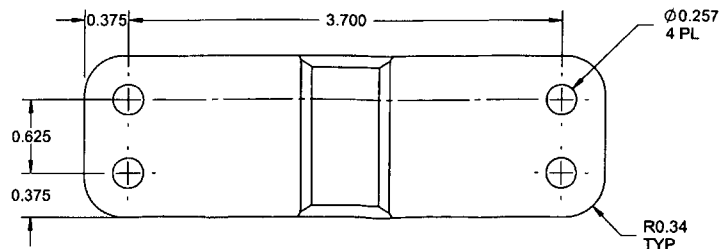
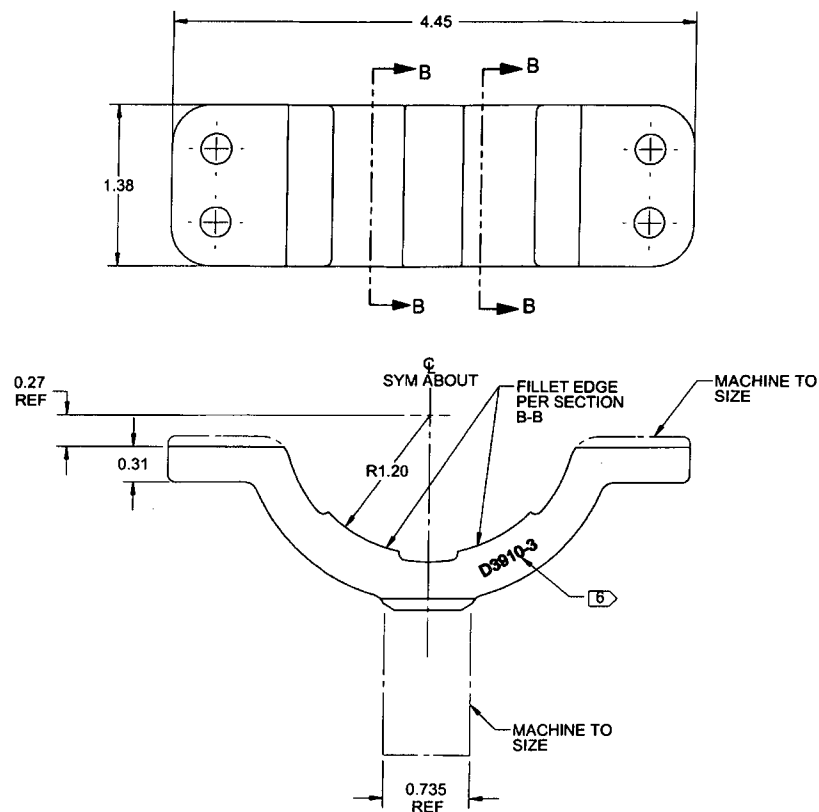
2014 JUN 05 *q*

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

RELEASED

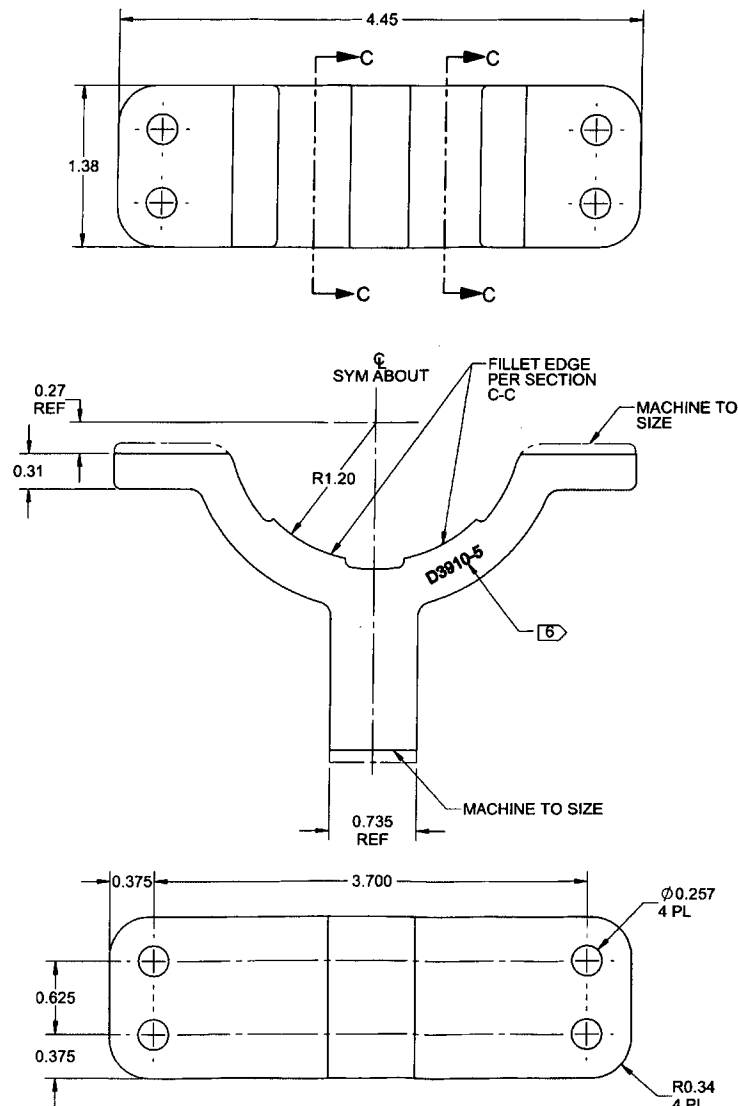
2014 JUN 05 *q7*

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MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	14.05.16		

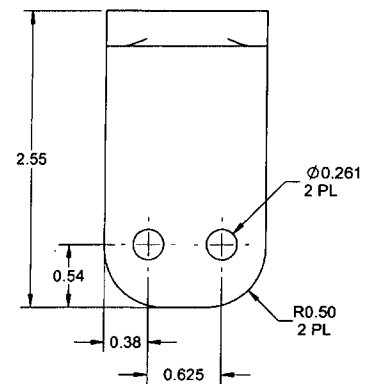
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



RELEASED

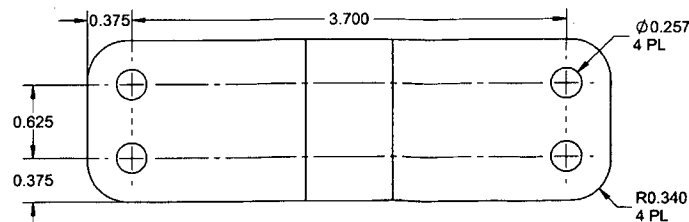
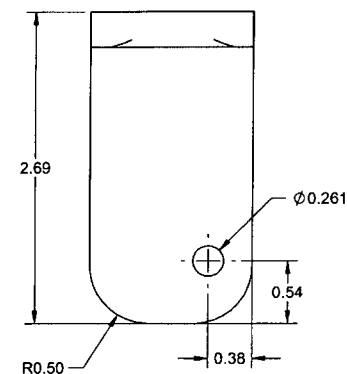
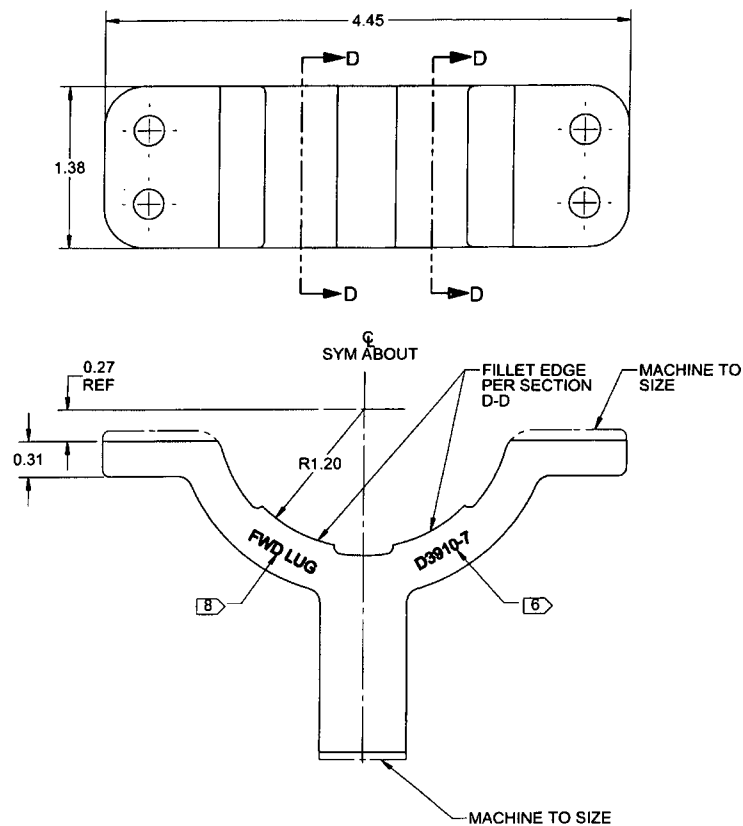
2014 JUN 05

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-7 X-TUBE LUG

RELEASED

2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28931

Purchase Order Date 6/24/2015

PO Print Date 6/25/2015

Page Number 2 of 4

Order From:

VC-MET003

Ship To: DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

3	D3394-1P ✓	Lug	7/15/2015	20.00 ✓	\$14.00	\$280.00
			Yes	Eac 1		
			7/15/2015			

AS PER DWG D3394 REV. B
B134002
ALODIDE AND PAINT AS PER QSI 005

8/15-07-06

Line Total: \$280.00

4	D3910-5P	Crosstube Lug	7/15/2015	30.00	\$14.00	\$420.00
			Yes	Eac 1		
			7/15/2015			

AS PER DWG D3910 REV. E
B134017
ALODIDE AND PAINT AS PER QSI 005

Line Total: \$420.00

5	D3910-7P	Crosstube Lug	7/15/2015 FN	30.00	\$14.00	\$420.00
			Yes	Eac 1		
			7/15/2015			

AS PER DWG D3910 REV. E
B133914
ALODIDE AND PAINT AS PER QSI 005

8/15-07-22

Note:

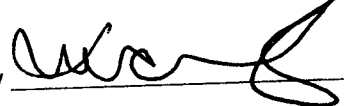
6/25/2015



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 20648
Date: Jul 21, 2015
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 28931	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jul 21, 2015

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug	Each	50		
D2230-3 Mounting Lug	Each	50	50	
D3394-1 Lug Assembly	Each	20		
3910-5 Lug	Each	30	30	
3910-7 Crosstube Lug, as per drawing D3910 PE1	Each	30	30	
D4091-1, Lug as per drawing D4091 Rev.A	Each	30		
3 boxes sent - boxes recieved The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by 		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2230-3	Lug Batch#127892	28931
30	D3910-5	Lug Batch#115529	28931
30	D3910-7	Lug Batch#115529	28931

PAINT BATCH # 20050
MATERIAL: supplied by DART

SP15-07-22

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, July 21, 2015